

Work Order ID 70539

Friday, June 10, 2011 2:56:37 PM



Page 1

Item ID: D206-628-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 6/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-033 CHG 002

CHK 7003

[Signature] 8/16/14

[Signature] for CL 11-6-22 Pto 7

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

[Signature] 11/06/22

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

[Signature] 8/16/14

[Signature] 72 LH



W/O: 70539		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/6/24	100	# Fix Laser Box and update the CHG #.					8 11/6/24

Part No: D206-628-033 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70539

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Friday, June 10, 2011 2:56:37 PM

Item ID: D206-628-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 6/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-628-033

Location: _____

PPP Rev: D04/6/27 (2)

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

04/6/27 (2)MF
11-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 70539

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A		Purchased	No			110	Each	1,929.000	3	6			
--------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--



BOLT

Location	Loc Qty	Loc Code
----------	---------	----------

ST350	1929	
117094	427	
117313	2	
117688	800	
117795	500	
117872	200	

AN4C14A		Purchased	No			110	Each	54.0000	8	16			
---------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--



Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

ST337	40	
117688	40	
ST357	14	
117366	14	

AN4C15A		Purchased	No			110	Each	125.0000	4	8			
---------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--



Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

ST358	125	
115835	25	
115936	2	
117441	48	
117795	50	

117441

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 70539

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

AN960C10 NAS1149C0363 Purchased No

110 Each

0.0000

3

6

✓



WASHER

AN960C416L NAS1149C0432B Purchased No

110 Each

0.0000

24

48

✓



WASHER

D2731-3 Manufactured No

110 Each

92.0000

4

8

✓



Mounting Lug

Location

Loc Qty

Loc Code

ST469

92

47967

61

52329

31

47967

D2732 Manufactured No

110 f

233.3281

2

4

✓



Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

233.32811

64283

233.32811

64283

D2842-041 Manufactured No

110 Each

0.0000

1

2



Step Assembly, 206 Float

D2844-1 Manufactured No

110 Each

11.0000

2

4



Arm

Location

Loc Qty

Loc Code

ST265

11

62954

11

62954

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 3

Work Order ID: 70539

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

D2844-3

Manufactured No

110

Each

16.0000

1

2

✓



Arm



JB R

Location

Loc Qty

Loc Code

ST265

4

62967

4

62967

ST266

12

66822

12

D3394-041

Manufactured No

110

Each

55.0000

4

8

✓



Lug Assembly



JB R

Location

Loc Qty

Loc Code

MEZZ

15

56528

15

56528 X 2

ST474

40

68257

40

68257 6 P

MS21043-4

Purchased No

110

Each

1,269.000

12

24

✓



Nut



JB 11/06/22

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

171

117423

171

ST301

1058

114784

47

115936

11

117601

500

117793

500

117601

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Friday, June 10, 2011 2:56:44 PM

Work Order ID: 70539

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3

Purchased

No

110

Each

148.0000

3

6

✓



Washer



JB

Location

Loc Qty

Loc Code

ST277

148

116373

48

117460

100

117460

NAS1515H4L

Purchased

No

110

Each

186.0000

24

48

✓



WASHER



JB 4/8/23

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

146

117363

146

117363

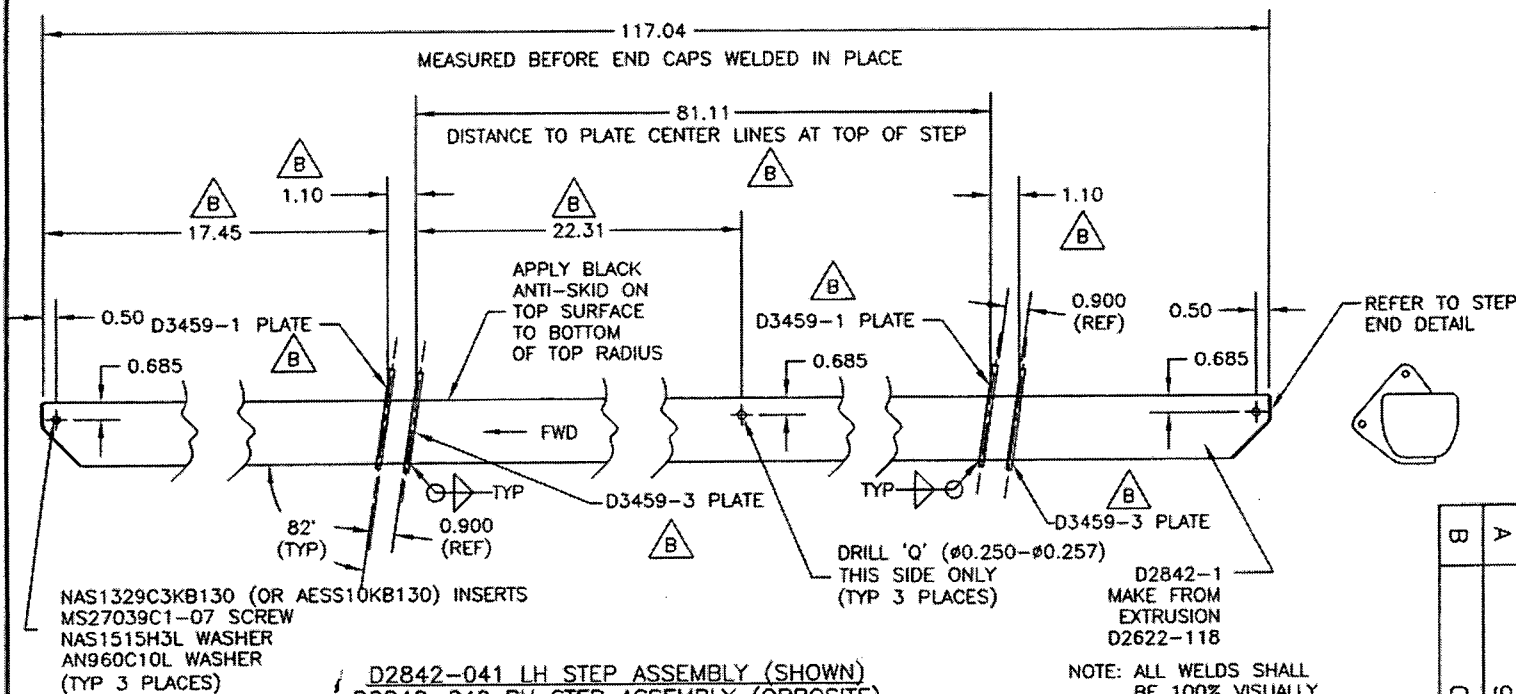
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23	05.09.23	206L/407 FLOAT STEP ASSEMBLY
A	98.10.13	NEW ISSUE
B	05.09.23	RE-DESIGN, ADD D3459-1/-3
		SHEET 1 OF 1
		SCALE NTS

RELEASED
05/11/14

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-628

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5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*LUG
4	4			8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*LUG
8	8	8	8			*MS35489-93	*GROMMET
1	1					D4064-041	MOUNTING LUG
1	1					*D4064-1	*LUG
2	2					*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	NAS1149C0363R	WASHER (OR AN960C10)
16	16					NAS1149C0463R	WASHER (OR AN960C416)
8	8	24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

5.3 QUICK RELEASE PIP PIN KIT

Qty -011	Part Number	Description
X	DSI9235-011	QUICK RELEASE PIP PIN KIT
4	BLRS-020	QUICK RELEASE PIN

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Revision: G

Date: 11.02.25

REFERENCE ONLY

Change Record

Part Number D206-628-0331-034
Description HELI-ACCESS-STEP Installation (407 FLOAT)

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